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**(54) METHOD FOR
CONTROLLING
PRESSURIZED COOLING
OF MOLTEN METAL IN
LOW PRESSURE CASTING
METHOD**

(57) Abstract:

PURPOSE: To prevent the development of misrun or gas defect, etc., by controlling filling-up of molten metal under pressurizing and cooling water flow rate under standardizing plural preset pressurizing patterns for the molten metal and the cooling patterns for a die in accordance with the die temp. and the molten metal temp.

CONSTITUTION: At the time of filling up the molten metal in a cavity 24 in the casting die 12 under pressurizing, the die temp. and the molten metal temp. are detected. Successively, the molten metal pressurizing pattern and the die cooling pattern corresponding to this die temp. and the molten metal temp. are selected among the plural preset

molten metal pressurizing patterns and the die cooling patterns. Based on this molten metal pressurizing pattern and the die cooling pattern, the molten metal is filled up under pressurizing and also the cooling water flow rate is controlled, to supply the molten metal in the casting die 12. For this purpose, suitable solidifying time of the molten metal is selected based on the pressurizing time of the molten metal corresponding to the die temp. and the molten metal temp. Further, by setting the casting speed corresponding to the die temp. and the molten metal temp., the molten metal is filled up into a cavity 24 at the optimum casting speed. Therefore, the solidification of the molten metal can be progressed under good casting condition in accordance with the molten metal temp. and the die temp.

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